

FIG. 1

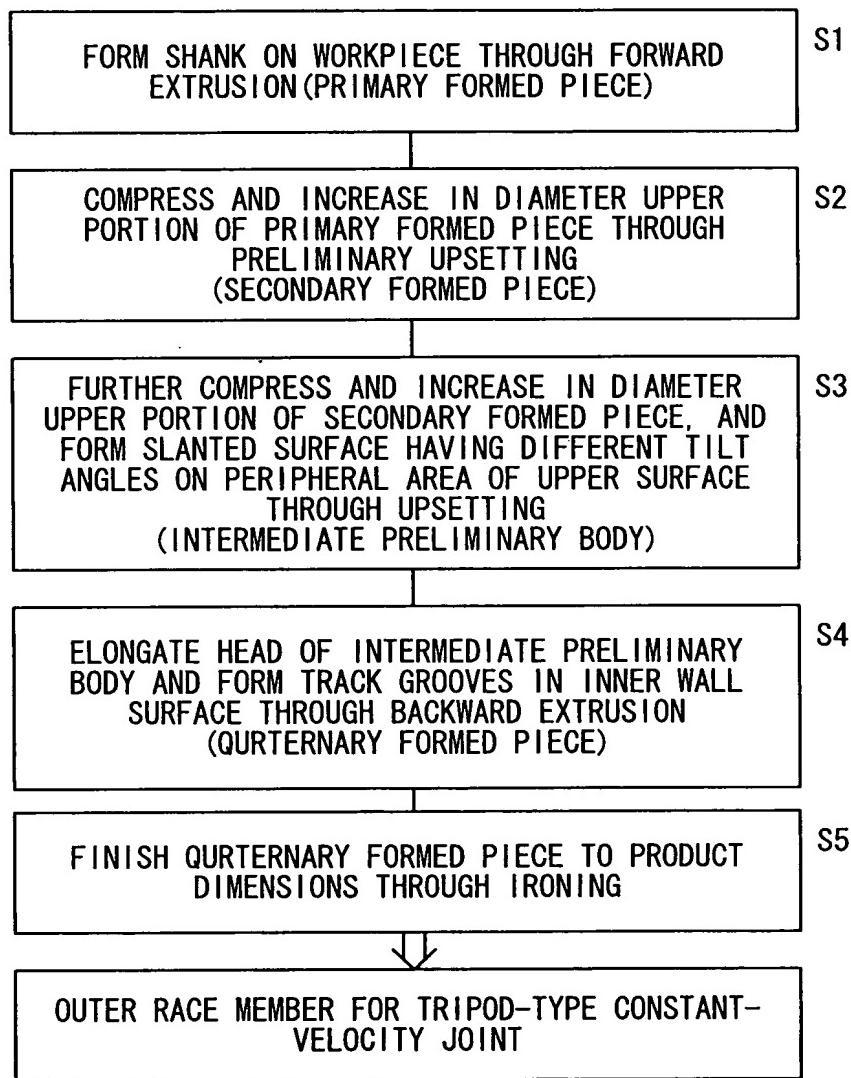
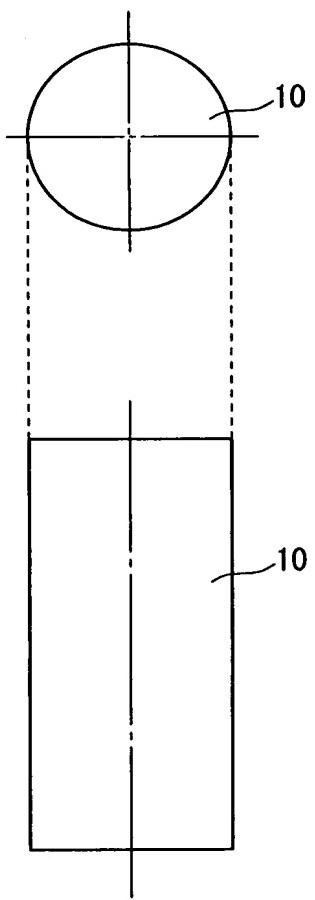
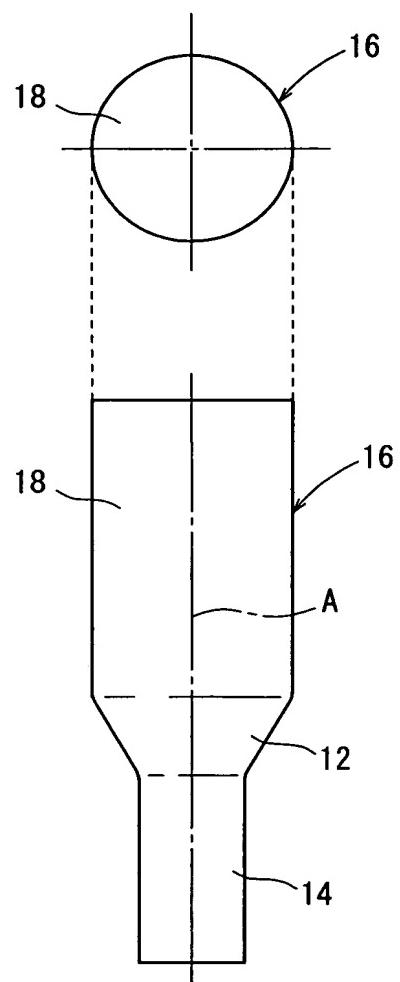


FIG. 2



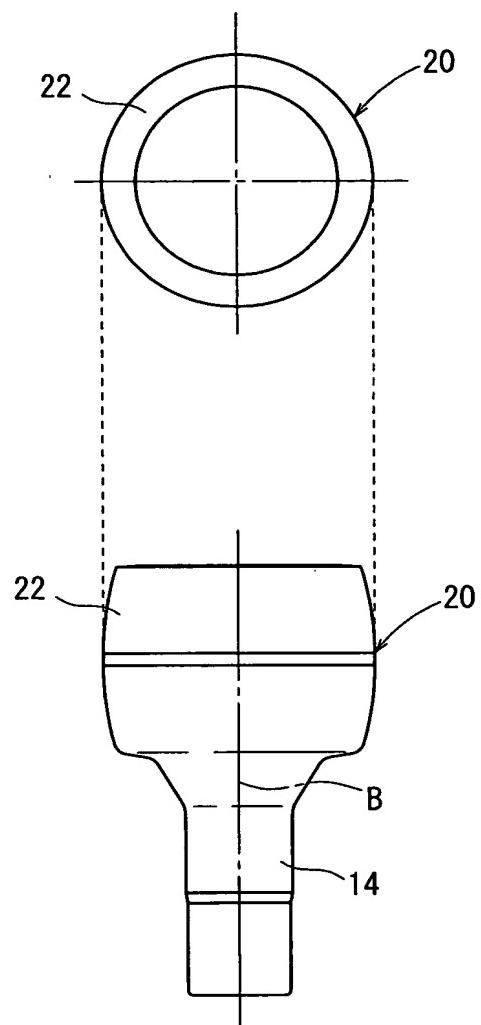
(WORKPIECE)

FIG. 3



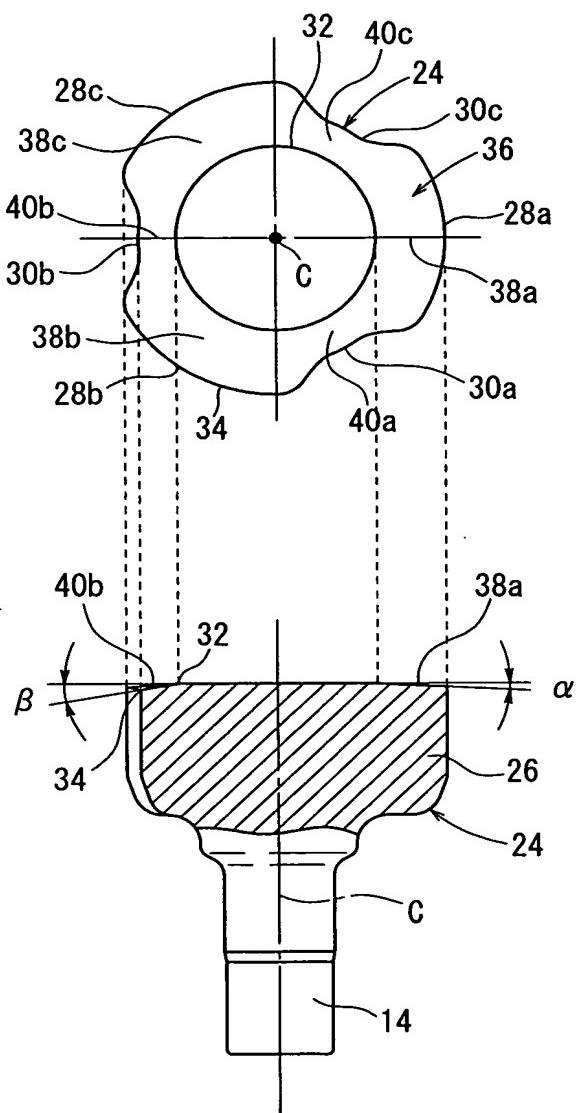
(PRIMARY FORMED PIECE)

FIG. 4



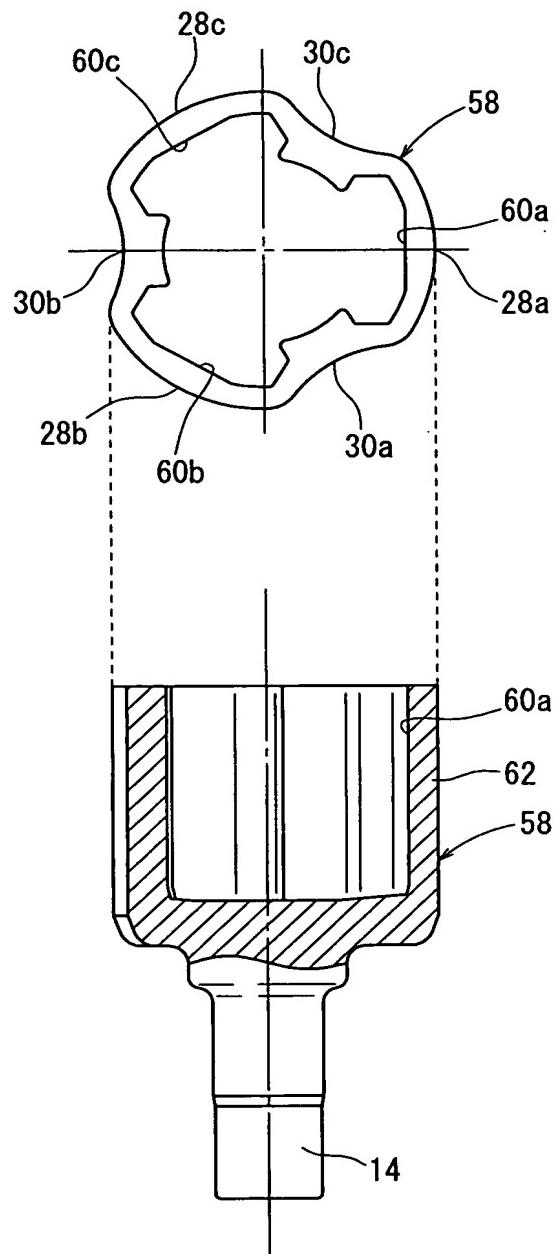
(SECONDARY FORMED PIECE)

FIG. 5



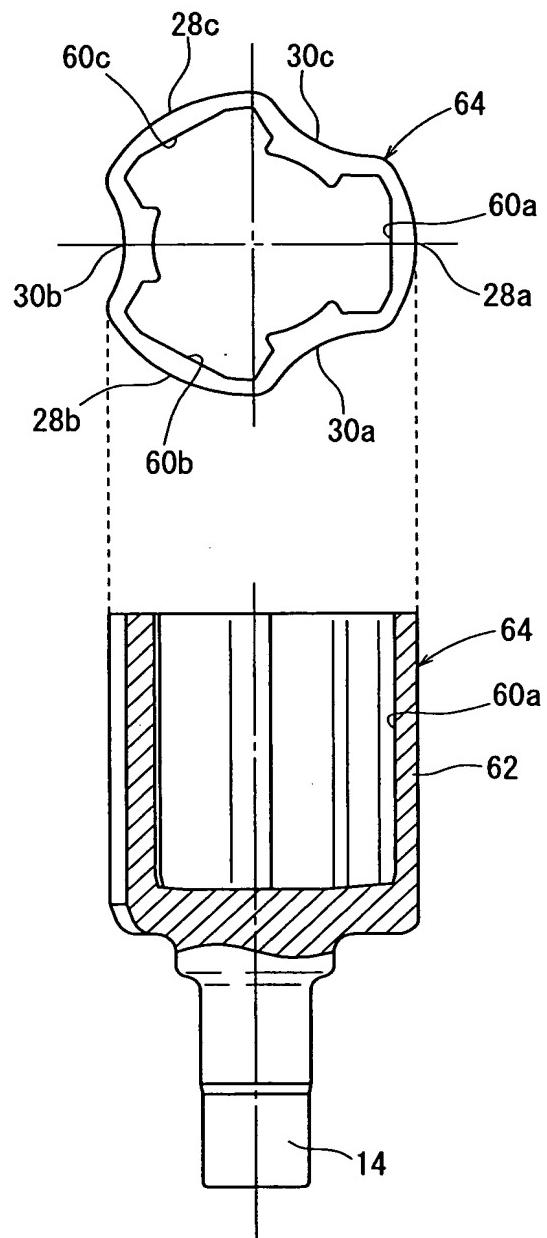
(INTERMEDIATE PRELIMINARY BODY)

FIG. 6



(QUARTERNARY FORMED PIECE)

FIG. 7



(COMPLETED PRODUCT)

FIG. 8

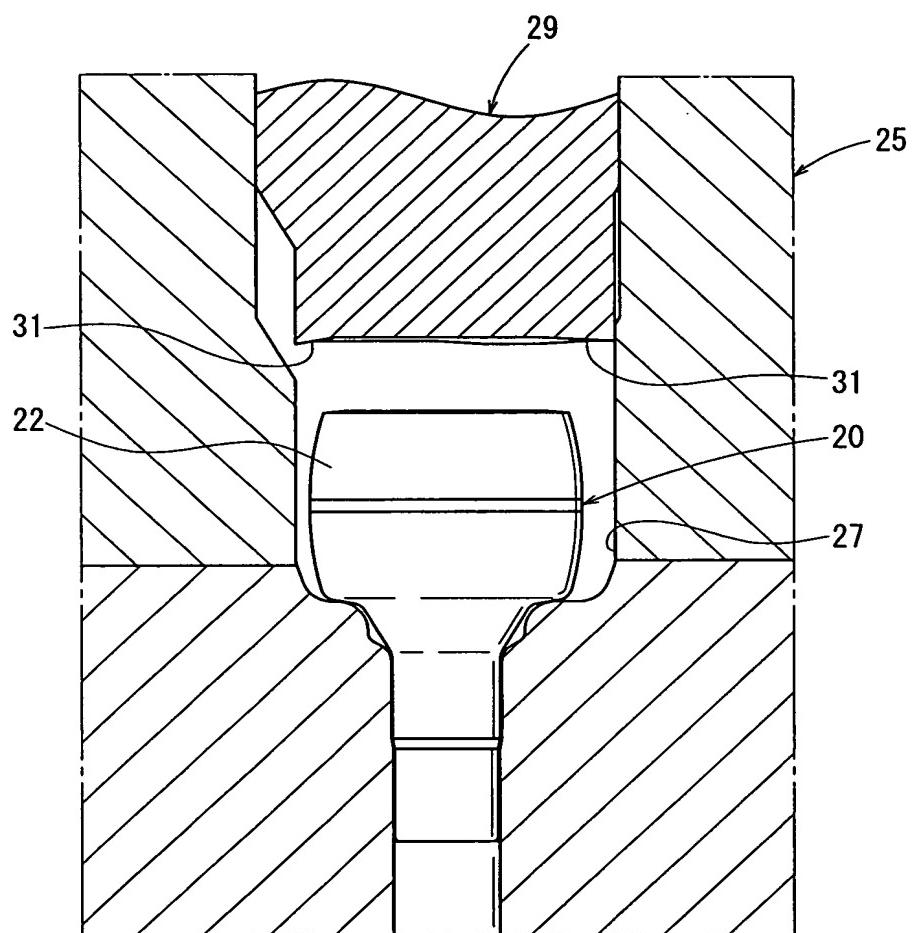


FIG. 9

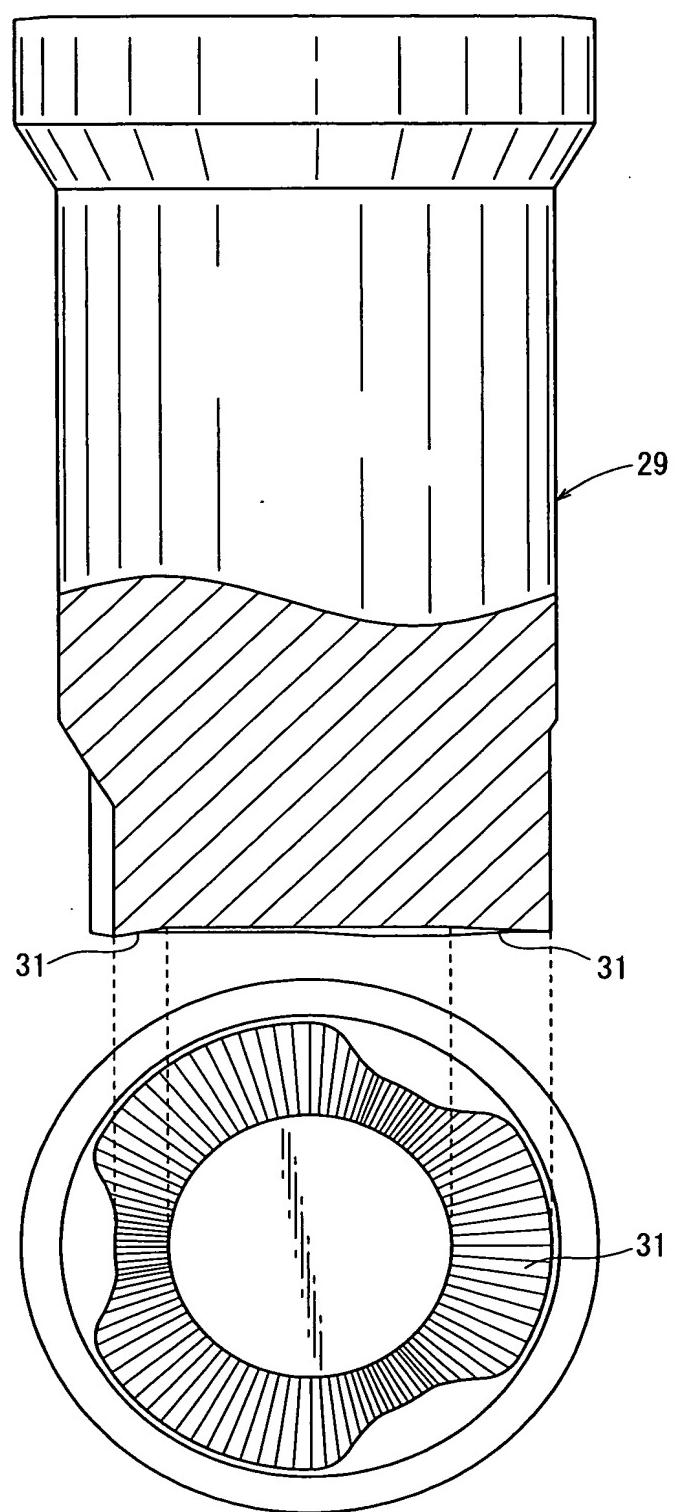


FIG. 10

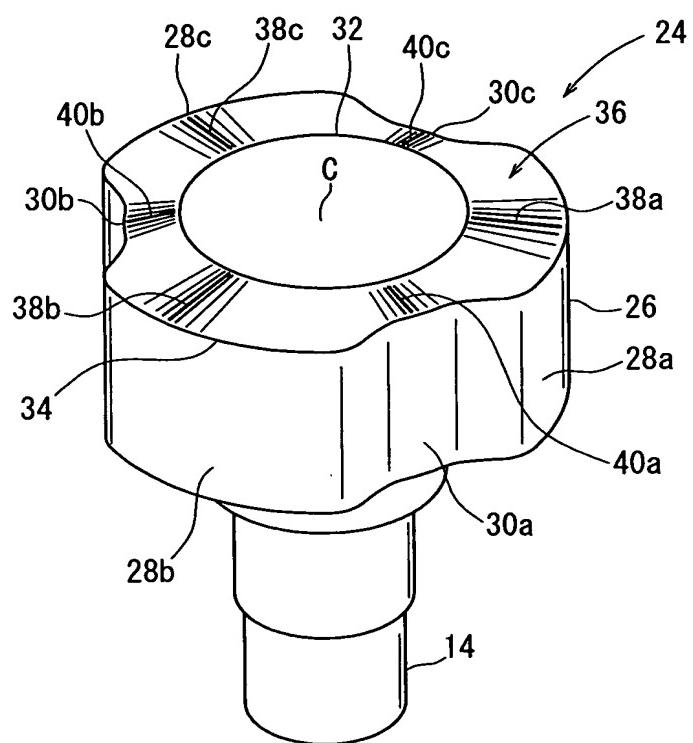


FIG. 11

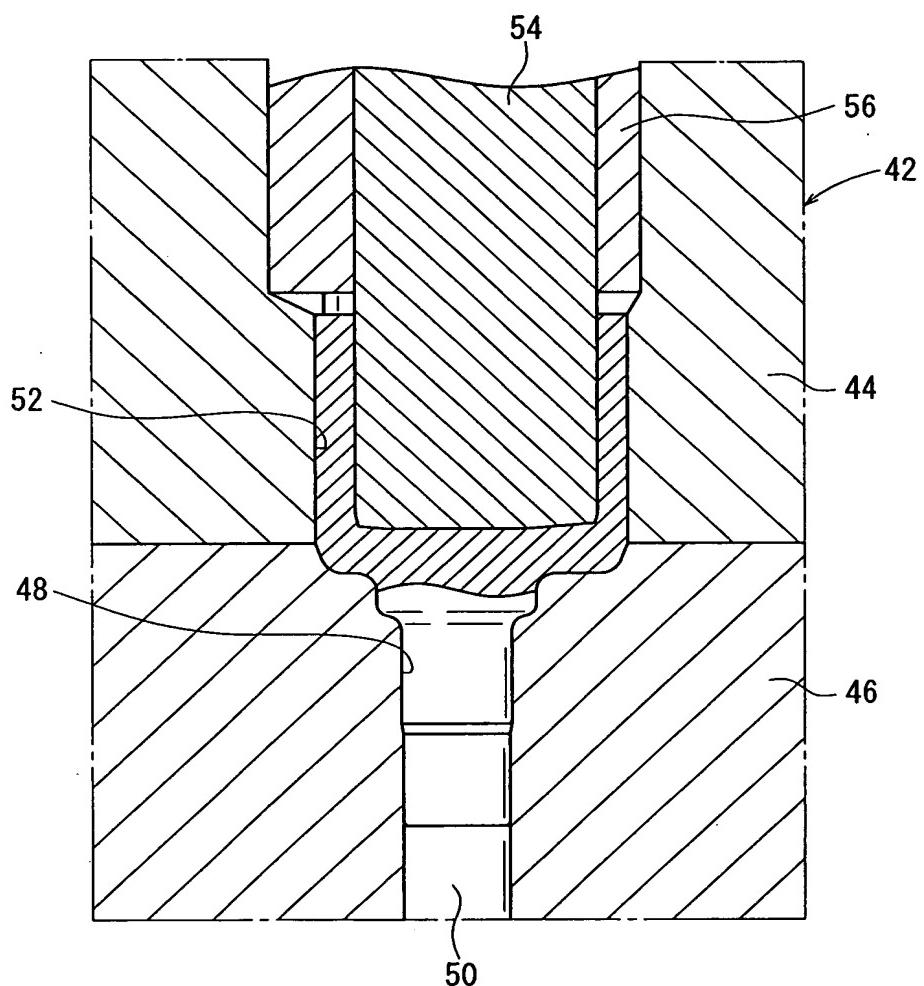


FIG. 12

LARGER-DIAMETER PORTIONS (α)	SMALLER-DIAMETER PORTION (β)	ANGLE DIFFERENCE	HOW MATERIAL IS FILLED	FORMED BODY IN NEXT STEP	JUDGEMENT
3°	3°	0°	△	PROBLEM IN PLACING FORMED BODY IN DIE	△
	6°	3°	○	NO PROBLEM	○
	9°	6°	○	NO PROBLEM	○
	10°	7°	○	NO PROBLEM	○
	12°	9°	○	NO PROBLEM	○
	15°	12°	○	NO PROBLEM	○
	18°	15°	◎	MATERIAL CRACKING	×

FIG. 13

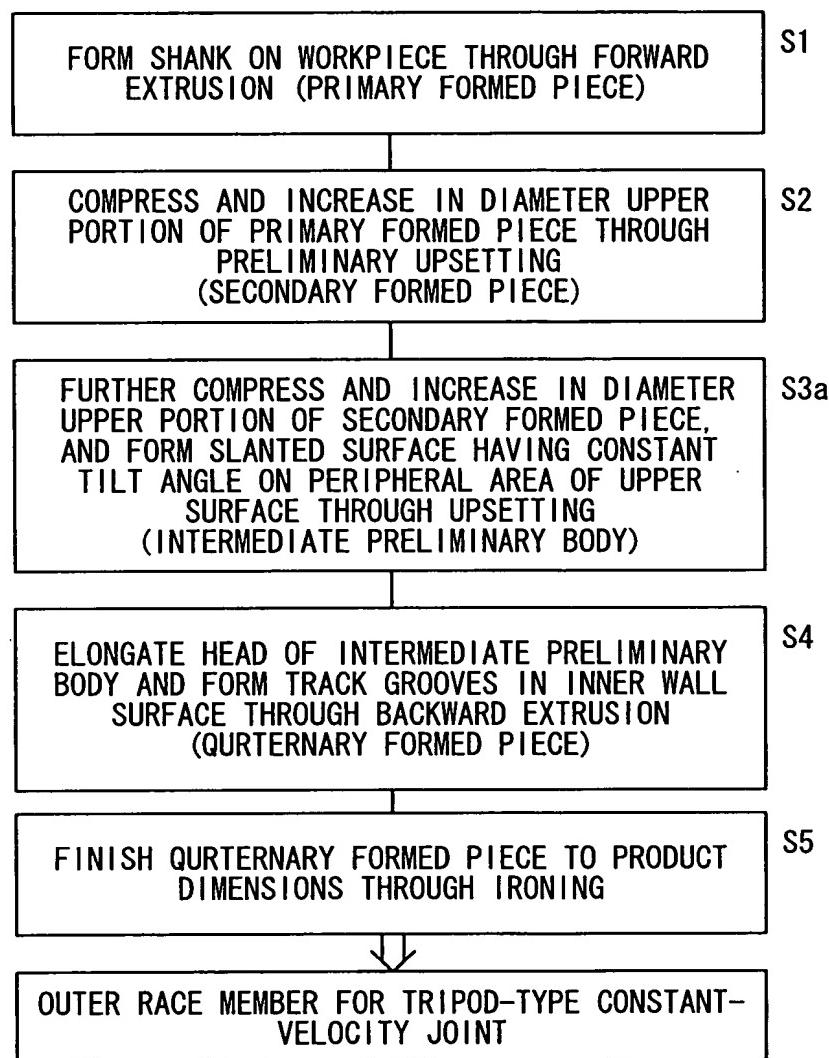
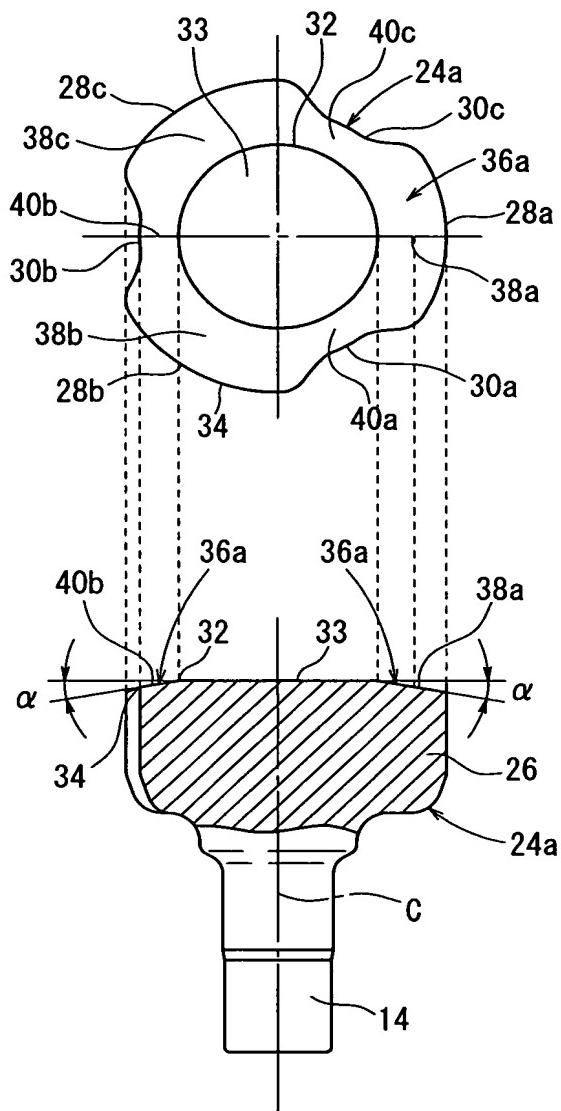


FIG. 14



(INTERMEDIATE PRELIMINARY BODY)

FIG. 15

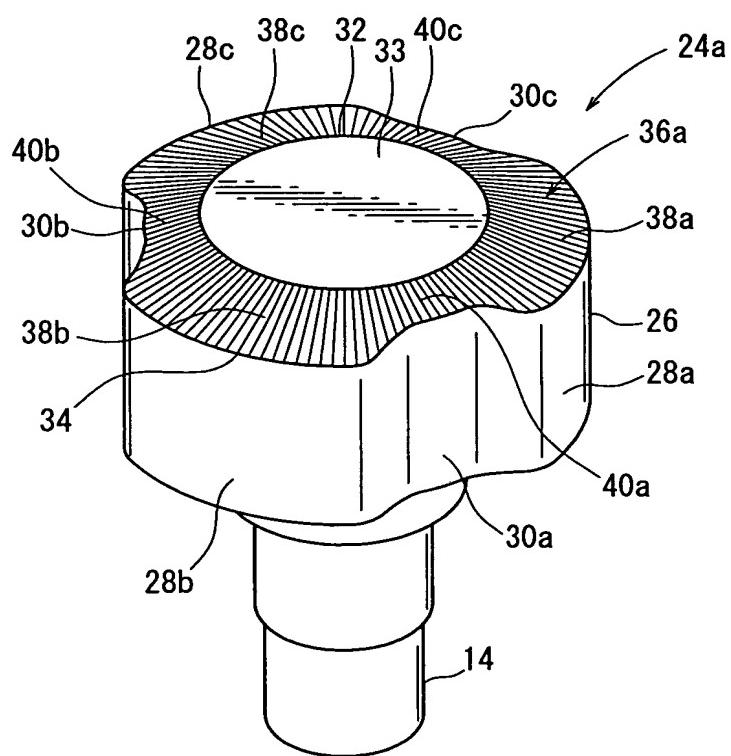


FIG. 16

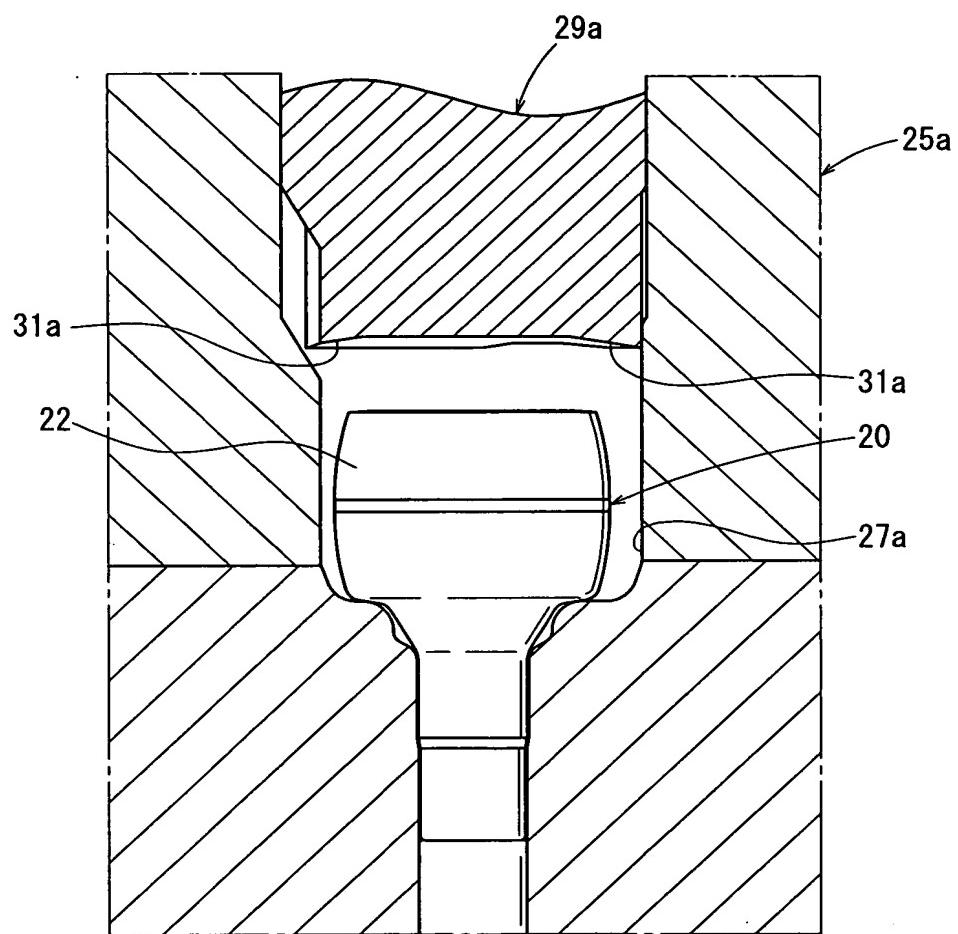


FIG. 17

